DEFENSE WORK MEASUREMENT STANDARD TIME DATA PROGRAM

PART TWO - PROCESSING OCCUPATIONS STANDARD TIME DATA

SECTION II - DWMSTDP ELEMENT LISTING

DEFENSE WORK MEASUREMENT STANDARD TIME DATA ELEMENTS

DATA SOURCE	OCCUP-ATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
NO	5XX	MAO	LDPC=1J	MOMHHD1	92	BASKET(DIP),HANG ON SUSPENSION BAR STARTS-WITH BASKET HELD IN BOTH HANDS INCLUDES-ALL THE MOTIONS NECESSARY TO MOVE BASKET TO SOLUTION,RELEASE RIGHT HAND HANDLE AND GRASP SUPPORT BAR(LEFT HAND MAINTAINS CONTROL OF BASKET),MOVE BAR THROUGH BASKET HANDLES,LIFT BASKET AND POSITION TO SUSPENSION BAR,RELEASE BAR AND BASKET(SIMO) ENDS-WITH RELEASE BAR AND BASKET CONDITIONS-BASKET AND BAR WEIGH TO 14 POUNDS
NO	5XX	MAO	LDPC1D1	MOMBR01	141	BASKET(WITH PARTS),REMOVE FROM SUSPENSION BAR STARTS-WITH REACH TO BASKET WITH BOTH HANDS INCLUDES-ALL THE MOTIONS NECESSARY TO REACH AND GRASP BASKET BY BOTH HANDLES,LIFT BASKET UP AND REMOVE BAR WITH RIGHT HAND,ASIDE BAR, GRASP HANDLE WITH RIGHT HAND AND LIFT BASKET OUT OF TANK,PLACE ASIDE,RELEASE ENDS-WITH BASKET ASIDE CONDITIONS-WEIGHT TO 14 POUNDS
NO	5XX	MAO	LDPC=1Y	MOMHR01	81	HOOK OR RACK,REMOVE FROM SUSPENSION BAR STARTS-WITH REACH TO HOOK OR RACK INCLUDES-ALL THE MOTIONS NECESSARY TO REACH TO OBJECT SUSPENDED OVER TANK OR VAT,GRASP OBJECT AND LIFT CLEAR OF SUSPENSION BAR,MOVE CLEAR OF TANK OR VAT ENDS-WITH HOOK OR RACK IN HAND CLEAR OF TANK CONDITIONS-WEIGHT TO 10 POUNDS
NO	5XX	MAO	LDPC=1G	MOMPMXX	VARIABLE	PART,MOUNT ON SPRING HOOK RACK STARTS-WITH REACH TO PART INCLUDES-ALL THE MOTIONS NECESSARY TO GET PART AND POSITION TO NOTCHES,MOVE INTO BOTTOM NOTCH AND TOP NOTCH,RELEASE PART ENDS-WITH RELEASE PART CONDITIONS-RACK IS HELD BY LEFT HAND TO STEADY
					99	CASE 01 MOUNT SMALL(LESS THAN 2.5 POUNDS)PART, EASY TO HANDLE
					144	02 MOUNT MEDIUM(2.5 TO 10 POUNDS)PART
NO	5XX	MAO	LDPC=1L	MOMPP01	98	PART(SMALL),PLACE ON TREE RACK STARTS-WITH REACH TO PART INCLUDES-ALL THE MOTIONS NECESSARY TO GET PART AND MOVE PART TO TREE RACK,POSITION PART ON RACK AND RELEASE ENDS-WITH PART RELEASED CONDITIONS-PART UP TO 2.5 POUNDS
NO	5XX	MAO	LDPC=1Z	MOMPRXX	VARIABLE	PART,REMOVE FROM RACK STARTS-WITH REACH TO PART ON RACK INCLUDES-ALL THE MOTIONS NECESSARY TO REACH AND GRASP PART,DISENGAGE PART FROM RACK,MOVE PART ASIDE AND RELEASE ENDS-WITH PART ASIDE CONDITIONS-PART WEIGHS TO 2.5 POUNDS
					54	CASE 01 REMOVE FROM HANGER RACK-STEADY RACK WITH LEFT HAND
					61	02 REMOVE FROM TREE RACK
NO	5XX	MAO	LDPC1A1	MOMPR03	80	PART(LARGE),REMOVE FROM SPRING RACK STARTS-WITH REACH TO PART ON RACK INCLUDES-ALL THE MOTIONS NECESSARY TO REACH AND GRASP PART ON RACK,MOVE PART OUT OF NOTCHES(4),DISENGAGE FROM RACK,ASIDE PART ENDS-WITH PART ASIDE CONDITIONS-PART WEIGHS 2.5 TO 10 POUNDS

DEFENSE WORK MEASUREMENT STANDARD TIME DATA ELEMENTS

DATA SOURCE	OCCUPATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
NAA	50X	MAA	SPLEDXX	SDPEAXX	VARIABLE	ERONEL,APPLY BY DIPPING STARTS-WITH REACH TO GET PART INCLUDES-ALL THE MOTIONS NECESSARY TO GET PART OFF BENCH,POSITION BOTTOM END IN ERONEL,ROTATE PART IN ERONEL,REMOVE PART FROM ERONEL AND ROTATE TO DRY,ASIDE PART TO DRIP RACK,REACH TO ERONEL RUNNERS,DISENGAGE ERONEL,REACH BACK TO RUNNERS AND ASIDE ERONEL TO VAT,GET PART OFF DRIP RACK,INVERT AND POSITION HANGER END IN ERONEL,ROTATE PART IN ERONEL,REMOVE PART AND ROTATE TO DRY,EXAMINE COAT,HANG ON COOLING RACK ENDS-WITH HANGER HANGING ON COOLING RACK CASE 01 SMALL PART-TO 10 POUNDS 02 MEDIUM PART-10 TO 30 POUNDS
					1347 1509	
NO	50X	MAO	LDPCK61	SJPPA01	723	PUTTY(PLATER),APPLY TO PLUG UP HOLE STARTS-WITH REACH TO PUTTY CAN INCLUDES-ALL THE MOTIONS NECESSARY TO PICK UP PUTTY CAN,REMOVE AND ASIDE LID(HOLDING IN LEFT HAND),DIG PUTTY OUT AND KNEAD WITH RIGHT HAND, RELEASE CAN,REACH TO AND HOLD PART,MOVE RIGHT HAND WITH PUTTY TO PART AND PUSH INTO HOLE, PRESS FLUSH,PUT THUMB ON PUTTY AND WIPE LEVEL, RELEASE PART AND PUTTY,GET AND ASIDE PART,PICK UP PUTTY CAN LID,PLACE ON CAN,ASIDE CAN ENDS-WITH ASIDE CAN CONDITIONS-AVERAGE WEIGHT OF PART IS 17.5 POUNDS
NAA	50X	MAA	CPLPN13	SJPPOXX	VARIABLE	PART,DIP IN WAX TO MASK FOR PLATING STARTS-WITH REACH TO GET PART INCLUDES-ALL THE MOTIONS NECESSARY TO GET PART,OPEN WAX TANK,DIP PART TO SPECIFIED DEPTH(TWICE),LIFT FROM WAX(TWICE),CHECK PART TO ASSURE PROPER COVERAGE ENDS-WITH CHECK COMPLETE CASE 01 SMALL PART 02 MEDIUM PART-INLCUDES PUTTING PART INTO AN OVEN AND REMOVING PART FROM OVEN-ALSO INCLUDES 1500 TMUS WARMING TIME AND TIME TO PUT ON AND TAKE OFF GLOVES
					1214 5086	
NAA	50X	MAA	SPLPN01	SJPPIXX	TABLE	PLUG(MASKING-LEAD),INSTALL STARTS-WITH REACH TO CLOSED DRAWER INCLUDES-ALL THE MOTIONS NECESSARY TO OPEN DRAWER WITHOUT LATCH,GET CUTTERS,PLIERS,HAMMER AND KNIFE,CLOSE DRAWER,DETERMINE HOLE SIZE, CUT PIECE OF LEAD,ASIDE CUTTERS,POSITION PLUG IN HOLE AND POSITION AND CLOSE PLIERS ON PLUG, EXAMINE FIT,PEEN WITH HAMMER(6 BLOWS),ASIDE PLIERS,GET KNIFE AND TRIM LEAD,EXAMINE,OPEN DRAWER,ASIDE TOOLS TO DRAWER AND CLOSE ENDS-WITH DRAWER CLOSED CONDITIONS-PLUGS TO 1/2 INCH DIAMETER(LEAD)-PREFORMED PLUGS IN CAN-CAN IS PICKED UP AND MOVED TO POSITION FOR USE

TYPE OF PLUG		FIRST PLUG A	EACH ADDITIONAL PLUG B
FORM PLUG FROM LEAD WIRE	A	1664	1027
PREFORMED PLUG (LEAD)	B	1178	941

DATA SOURCE	OCCUPATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
NAA	50X	MAA	CPLPLH3	SJPPPXX	VARIABLE	PART,PREPARE TO LOAD FOR PLATING STARTS-WITH REACH TO GET HOLDER(SPRING OR WIRE) INCLUDES-ALL THE MOTIONS NECESSARY TO GET HOLDER,GET PART AND INSTALL PART IN HOLDER, REMOVE PART FROM HOLDER AND PLACE IN BASKET FOR RINSE AFTER TREAT,REMOVE PART FROM BASKET AFTER RINSE AND ASIDE PART ENDS-WITH ASIDE PART CONDITIONS-TREAT 12 PARTS PER OCCURENCE-DOES NOT INCLUDE TREAT OR RINSE TIME-DOES NOT INCLUDE WALKING TO GET PARTS OR HOLDER
					272	CASE 01 PART INSTALLED IN SPRING TYPE HOLDER
					839	02 PART STRUNG ON WIRE-GET WIRE(4-5 FEET) FROM ROLL AND CUT WITH DYKES
NAA	50X	MAA	SPLPRXX	SJPPRXX	VARIABLE	PLUG(MASKING),REMOVE STARTS-WITH CHECK FOR PLUG LOCATION INCLUDES-ALL THE MOTIONS NECESSARY TO LOCATE PLUG,GET TOOL(S),REMOVE AND ASIDE PLUG,ASIDE TOOL(S) ENDS-WITH ASIDE PLUG AND TOOL(S)
					401	CASE 01 REMOVE FIRST OR ONLY LEAD PLUG-HAMMER AND PUNCH-ONE BLOW
					476	02 REMOVE EACH ADDITIONAL LEAD PLUG-HAMMER AND PUNCH-ONE BLOW(INCLUDES REPOSITION PART UP TO 30 POUNDS ENW)
					488	03 REMOVE FIRST OR ONLY PLASTIC PLUG WITH HAMMER AND PUNCH-FOUR BLOWS
					359	04 REMOVE FIRST OR ONLY PLASTIC PLUG WITH PLIERS
					378	05 REMOVE EACH ADDITIONAL PLASTIC PLUG WITH PLIERS(INCLUDES REPOSITION PART TO 30 POUNDS ENW)
					403	06 REMOVE FIRST OR ONLY PLASTIC PLUG WITH AWL(INCLUDES REMOVING PLUG FROM AWL)
					409	07 REMOVE EACH ADDITIONAL PLASTIC PLUG WITH AWL(INCLUDES REPOSITION PART TO 30 POUNDS ENW AND REMOVE PLUG FROM AWL)
NAA	50X	MAA	SPLPNXX	SJPPSXX	VARIABLE	PLUG(MASKING),SEAT IN HOLE STARTS-WITH CHECK LOCATION AND HOLE SIZE INCLUDES-ALL THE MOTIONS NECESSARY TO CHECK LOCATION AND SIZE OF HOLE,GET CAN OF PLUGS (PLASTIC)OR GET RUBBER PLUGS FROM STORAGE BIN, GET TOOLS,POSITION PLUG IN HOLE,SEAT PLUG ENDS-WITH ASIDE TOOL(S) CONDITIONS-1/4 INCH PLASTIC AND RUBBER PLUGS-DIAGONALS USED TO CUT AND TRIM PLUGS(PLASTIC)-DOES NOT INCLUDE WALKING TO AND FROM STORAGE-DOES NOT INCLUDE TRIMMING PLUGS TO SIZE
					691	CASE 01 SEAT PLUG-EXTERIOR HOLE-THREE HAMMER BLOWS-GET TOOLS FROM DRAWER(NO LATCH) AND RETURN TO DRAWER-PLASTIC PLUGS-FIRST OR ONLY PLUG
					407	02 SEAT PLASTIC PLUG-EACH ADDITIONAL-EXTERIOR HOLE
					934	03 SEAT RUBBER PLUG-EXTERIOR/INTERIOR HOLE-SEAT W/THREE HAMMER BLOWS-GET HAMMER FROM AND RETURN TO DRAWER-OPEN AND CLOSE TWO TIMES-FIRST OR ONLY PLUG
					528	04 SEAT RUBBER PLUG-EXTERIOR/INTERIOR HOLE-EACH ADDITIONAL PLUG

DEFENSE WORK MEASUREMENT STANDARD TIME DATA ELEMENTS

DATA SOURCE	OCCUP-ATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
NAA	50X	MAA	SPLPR05	SJPPTXX	VARIABLE	PLUG(RUBBER MASKING),TAKE OUT STARTS-WITH EXAMINE PART FOR LOCATION INCLUDES-ALL THE MOTIONS NECESSARY TO LOCATE PLUG,GET SCREWDRIVER,PRY OUT PLUG,GRASP PLUG AND USE SCREWDRIVER TO CLEAN ERONEL FROM PLUG, ASIDE SCRAP ERONEL,SCREWDRIVER AND PLUG ENDS-WITH ASIDE PLUG
					313	CASE 01 REMOVE FIRST OR ONLY PLUG
					434	02 REMOVE EACH ADDITIONAL PLUG
NO	50X	MAA	LDPCK62	SJPRP01	522	PUTTY(PLATERS),REMOVE FROM HOLE STARTS-WITH REACH TO PART INCLUDES-ALL THE MOTIONS NECESSARY TO GET PART AND TOOL,USE TOOL TO PICK PUTTY OUT OF HOLE, SCRAPE PUTTY OFF OF TOOL ON EDGE,ASIDE TOOL AND PART ENDS-WITH ASIDE TOOL AND PART CONDITIONS-PART WEIGHS AVERAGE OF 17.5 POUNDS
NAA	50X	MAA	SPLSNXX	SJPSIXX	VARIABLE	SEALANT,INSTALL IN CAVITY STARTS-WITH REACH TO GET SEALANT CAN INCLUDES-ALL THE MOTIONS NECESSARY TO GET CAN AND PRY OFF LID,ASIDE LID,REACH INTO CAN AND GET SMALL AMOUNT OF PUTTY(SEALANT)ON FINGERS, PLACE SEALANT BETWEEN HANDS AND KNEAD TO SIZE,EXAMINE FOR SIZE,ASIDE TO TABLE,PINCH OFF SMALL PIECE,PLACE SEALANT IN SPOT TO BE PLUGGED,PRESS WITH THUMB TO SEAT,EXAMINE,GET KNIFE AND REMOVE EXCESS SEALANT,PLACE EXCESS IN LOW SPOT,PRESS TO SEAT,SCRAPE OFF EXCESS, EXAMINE,ASIDE KNIFE,GET LID AND PLACE ON SEALANT CAN,ASIDE CAN ENDS-WITH ASIDE CAN
					1714	CASE 01 INSTALL IN CAVITY
					521	02 INSTALL IN EACH ADDITIONAL CAVITY
NAA	50X	MAA	SPLSRXX	SJPSRXX	VARIABLE	SEALANT,REMOVE STARTS-WITH REACH TO GET KNIFE INCLUDES-ALL THE MOTIONS NECESSARY TO GET KNIFE,LOCATE SEALANT AREA,POSITION KNIFE TO SEALANT,REMOVE AND ASIDE SEALANT;DRESS AREA WITH KNIFE,EXAMINE AREA ENDS-WITH SEALANT ASIDE CONDITIONS-CAVITY TO 1/2 CUBIC INCH
					649	CASE 01 REMOVE FROM FIRST CAVITY
					503	02 REMOVE FROM EACH ADDITIONAL CAVITY
NAA	50X	MAA	SPLOL01	SOHPPXX	VARIABLE	PART,PLACE IN PLATING TANK STARTS-WITH STOOP TO GET PART INCLUDES-ALL THE MOTIONS NECESSARY TO GET PART (UNIT)AND PLACE IN TANK,PLACE BAR OVER THREE UNITS,GET CLAMPS(TWO),POSITION AND TIGHTEN CLAMPS ENDS-WITH CLAMPS TIGHTENED CONDITIONS-DOES NOT INCLUDE WALKING TO GET PARTS(UNITS)OR CLAMPS
					591	CASE 01 SECURED WITH BAR AND TWO CLAMPS
					350	02 SECURED WITH ONE CLAMP
NAA	50X	MAA	SPLE0XX	SPAEAXX	VARIABLE	ERONEL,APPLY WITH APPLICATOR(TOUCH UP) STARTS-WITH REACH TO GET APPLICATOR INCLUDES-ALL THE MOTIONS NECESSARY TO GET APPLICATOR,DIP INTO ERONEL,MOVE APPLICATOR TO PART,APPLY TO SURFACE,ASIDE APPLICATOR ENDS-WITH APPLICATOR ASIDE
					303	CASE 01 APPLY TO FIRST TWO SQUARE INCH AREA
					.219	02 APPLY TO EACH ADDITIONAL TWO SQUARE INCH AREA

DATA SOURCE	OCCUPATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
NAA	500	MAA	CPLFDC7	SDPPE01	4400	PART,ETCH(NITAL) STARTS-WITH REACH TO GET PART INCLUDES-ALL THE MOTIONS NECESSARY TO GET PART AND DIP INTO NITRIC ACID SOLUTION,REMOVE, RINSE PART IN COLD WATER,DIP PART IN HYDRO-CHLORIC ACID,REMOVE,RINSE IN COLD WATER,RINSE IN ALKALINE SOLUTION,AIR DRY PART,EXAMINE PART ENDS-WITH PART EXAMINED CONDITIONS-SMALL OR MEDIUM SIZE PART-TIME TO MOVE PART BETWEEN TANKS AND TO TANKS IS NOT INCLUDED-DRAIN AND TANK TIME NOT INCLUDED
NAA	500	MAA	SPLAR01	SJPAI01	1561	ANODE,INSTALL AND REMOVE STARTS-WITH SELECT ANODE IN STORAGE INCLUDES-ALL THE MOTIONS NECESSARY TO SELECT ANODE,PICK UP AND MOVE INTO POSITION,ALIGN HOLE WITH NOTCH OR STUD,REMOVE AND INSTALL THREE WING NUTS,REMOVE AND ASIDE ANODE ENDS-WITH ASIDE ANODE CONDITIONS-DOES NOT INCLUDE WALK TO GET ANODE AND RETURN
NAA	500	MAA	SCLDU01	SJPBE01	427	BOOTH(SAND BLAST),ENTER/EXIT STARTS-WITH REACH TO DOOR HANDLE INCLUDES-ALL THE MOTIONS NECESSARY TO GRASP AND TURN HANDLE 90 DEGREES TO UNLATCH,PULL HANDLE THRU SLOT AND PULL DOOR OPEN,WALK FOUR PACES THRU DOOR,TURN AND GRASP DOOR,PULL DOOR SHUT,REACH THRU SLOT TO HANDLE,PULL TO SEAT AND TURN 90 DEGREES TO LATCH ENDS-WITH DOOR CLOSED,HAND ON HANDLE
WA	500	MAA	SPLEMXX	SJPETXX	TABLE	ERONEL,TRIM FROM PERIMETER PLATE AREA STARTS-WITH REACH TO PART ON DRIP RAIL INCLUDES-ALL THE MOTIONS NECESSARY TO GET ERONEL COATED PART,GET KNIFE,CUT ERONEL,ASIDE KNIFE,ASIDE ERONEL SCRAP,REPOSITION PART,ASIDE PART TO READY RACK ENDS-WITH PART ASIDE CONDITIONS-PART OVER 30 POUNDS-NOT POSITIONED PRIOR TO CUTTING-INTERNAL TRIMMING AND CUTTING IS DONE BLIND

SIZE OF PART		REMOVE ERONEL FROM EXTERNAL SURFACE	INTERNAL SURFACE EASY ACCESS	INTERNAL SURFACE DIFFICULT ACCESS
		A	B	C
PART TO 30 POUNDS				
FIRST INCH	A	716	1217	1324
EACH ADDL.INCH	B	177	206	359
PART OVER 30 POUNDS				
FIRST INCH	C	394	652	755
EACH ADDL.INCH	D	244	243	488

NC	500	MAN	LDPCK5J	SJPLC01	268	LEAD(ELECTRIC PLATING),CONNECT TO ANODE STARTS-WITH REACH TO GET "C" CLAMP INCLUDES-ALL THE MOTIONS NECESSARY TO GET "C" CLAMP,GET ELECTRICAL LEAD,POSITION CLAMP AND LEAD TO PART,TIGHTEN CLAMP ENDS-WITH CLAMP TIGHTEN,RELEASED

DEFENSE WORK MEASUREMENT STANDARD TIME DATA ELEMENTS

DATA SOURCE	OCCUP-ATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
NAA	500	NAA	SPLRN01	SJPRI01	805	ROBBER(WIPE),INSTALL STARTS-WITH SIMO REACH TO CUTTERS AND WIRE INCLUDES-ALL THE MOTIONS NECESSARY TO GET AND CUT WIRE,ASIDE CUTTERS,POSITION AND HOLD ONE END OF WIRE IN GROOVE OF PART,WRAP WIRE AROUND TWICE,EXAMINE,TWIST WIRE WITH DUCKBILLS TO SECURE,HOLD WIRE WITH DUCKBILLS AND TRIM EXCESS,GET SCREWDRIVER AND PRESS END OF WIRE TO FLATTEN,ASIDE SCREWDRIVER,DUCKBILLS ENDS-WITH TOOLS ASIDE CONDITIONS-PARTS TO SIX INCHES DIAMETER
NAA	500	NAA	SPLRRXX	SJPRRXX	VARIABLE	ROBBER,REMOVE STARTS-WITH REACH TO GET TOOL INCLUDES-ALL THE MOTIONS NECESSARY TO GET TOOL AND PRY OR LIFT END OF ROBBER FROM GROOVE, GRASP ROBBER AND PULL FROM GROOVE,CUT WIRE, ASIDE ROBBER AND TOOLS AND WIRE ENDS-WITH ASIDE ROBBER AND TOOLS AND WIRE
					446	CASE 01 WIRE ROBBER-CUT AND REMOVE 12 INCHES-FIRST 12 INCHES-LIFT END WITH SCREW-DRIVER-PULL WITH PLIERS
					92	02 WIRE ROBBER-EACH ADDITIONAL 12 INCHES-PULL WITH PLIERS
					323	03 LEAD SOLDER ROBBER-LIFT END WITH KNIFE AND PULL LOOSE WITH PLIERS-FIRST SIX INCHES
					61	04 LEAD SOLDER ROBBER-EACH ADDITIONAL SIX INCHES-PULL LOOSE WITH PLIERS
					767	05 LEAD STRIP ROBBER-CUT TIE DOWN WIRE, PRY UP ROBBER WITH KNIFE,PULL LOOSE WITH PLIERS-FIRST SIX INCHES
					138	06 LEAD STRIP ROBBER-EACH ADDITIONAL SIX INCHES
NAA	500	NAA	SPLPOXX	SPAMAXX	TABLE	MICROMASK,APPLY TO PART WITH BRUSH STARTS-WITH REACH TO CAN OF MICROMASK INCLUDES-ALL THE MOTIONS NECESSARY TO GET CAN OF MICROMASK,REMOVE AND ASIDE CAN COVER,GET PAINT BRUSH FROM SOLVENT,SHAKE SOLVENT OFF BRUSH,DIP BRUSH IN MICROMASK,WIPE OFF EXCESS, APPLY MICROMASK TO SURFACE,RETURN BRUSH TO CAN,REPLACE LID ON MICROMASK CAN ENDS-WITH BRUSH RELEASED IN SOLVENT

		SURFACE TO PAINT INTERNAL A	EXTERNAL B
ONE SQUARE INCH FIRST	A	426	373
EACH ADDL	B	109	84
ONE LINEAR INCH SURFACE ADJACENT TO EDGE OF PLATING FIRST	C	522	467
EACH ADDL	D	205	151

DEFENSE WORK MEASUREMENT STANDARD TIME DATA ELEMENTS

DATA SOURCE	OCCUPATION	QUALITY	SOURCE CODE	DWMSTOP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
FFD	503	TBA	GECBLWX	MCLPBXX	VARIABLE	PART,BLAST(WET OR VAPOR),AND RINSE STARTS-WITH PART IN MACHINE INCLUDES-ALL THE MOTIONS NECESSARY TO START MACHINE,BLAST PART,STOP MACHINE,SPRAY TO RINSE ENDS-WITH RINSE COMPLETE CONDITIONS-TIME FOR VERY LARGE PART IS LESS THAN TIME FOR LARGE PART BECAUSE SURFACE AREA OF VERY LARGE PART IS GENERALLY SMALLER AND MORE EVEN BUT WEIGHT OF PARTS PLACED THEM IN VERY LARGE CATEGORY
					1530	CASE 01 SMALL PART(BASED ON 100 PARTS PER BASKET)-COMPRESSOR BLADE,ETC.
					9802	02 MEDIUM PART(PARTS INDIVIDUALLY WORKED)
					23117	03 LARGE PART-(BASED ON TWO PARTS PER PALLET)
					18567	04 VERY LARGE PART-(BASED ON ONE PART PER OCCURENCE)
					2617	05 MEDIUM PART(IN BASKET-AVERAGE 40 PER BASKET)
FFD	503	TCA	GECBLW1	MCLPB06	9350	PARTS(IN BASKET),BLAST(WET) STARTS-WITH MACHINE ON AFTER LOADING INCLUDES-ALL THE TIME AND MOTIONS NECESSARY TO WET BLAST A LOAD OF SMALL PARTS IN BASKETS OF SMALL PARTS IN A ROTATING BARREL TYPE WET BLAST MACHINE ENDS-WITH REACH TO AIR VALVE CONDITIONS-TIME IS PER MACHINE LOAD CONSISTING OF TWO BASKETS
FFE	503	MAA	IOFEGKG	MCLPD01	582	PARTS(IN BASKET),DRAIN STARTS-WITH BASKET HANDLES IN HAND INCLUDES-ALL THE MOTIONS NECESSARY TO REMOVE BASKET FROM FLUID,RAISE ON END OF BASKET,DRAIN PARTS IN BASKET,LOWER END OF BASKET ENDS-WITH BASKET IN HAND CONDITIONS-ENW OF BASKET IS 20 POUNDS
FFD	503	TAA	GECBLW2	MCLPR01	256	PARTS(IN BASKET),RINSE IN MACHINE STARTS-WITH WATER HOSE IN HAND,WATER ON INCLUDES-ALL THE TIME AND MOTIONS NECESSARY TO SPRAY WATER OVER BASKET OF SMALL PARTS IN A ROTATING BARREL TYPE WET BLAST MACHINE TO RINSE PARTS IN BASKET ENDS-WITH PARTS RINSED,WATER ON CONDITIONS-TWO BASKETS OF PARTS MAKE UP ONE MACHINE LOAD-TIME IS PER MACHINE LOAD

DEFENSE WORK MEASUREMENT STANDARD TIME DATA ELEMENTS

DATA SOURCE	DOCUMENTATION	QUALITY	SOURCE CODE	OWNSTAD ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
AF	503	TBW	SCLXCXX	TCLPCXX	TABLE	PART,CLEAN AND AIR DRY STARTS-WITH PART IN POSITION TO CLEAN OR DRY INCLUDES-ALL THE PROCESS TIME NECESSARY TO STEAM/IMMERSION CLEAN/AIR DRY A PART ENDS-WITH PROCESS COMPLETE CONDITIONS-HEAVY GREASE IS THAT WHICH IN ANY WAY HIDES THE CONFIGURATION OF THE PART(HIDDEN NUTS OR BOLTS,FLANGES,ETC.)-LIGHT GREASE IS THAT WHICH DOES NOT HIDE THE CONFIGURATION-STEAM CLEANER,NON-PORTABLE(CLAYTON)-AIR PRESSURE,100 TO 150 PSI-CLEANING SOLVENTS, VARSOL,BENDIX,OAKITE-IMMERSE AND SCRUB WITH BRUSH

OPERATION		SIZE OF PART/OBJECT TO 108 CU.IN. (3X6X6) A	109 TO 432 CU.IN. B	OVER 432 CU.IN. (6X6X12) C
TANK CLEAN (IMMERSION)	A	420	680	1140
AIR DRY (SLOW OFF)	B	480	570	1230

OPERATION		TO 7780 CU.IN. (12X12X36) D	OVER 7780 CU.IN. E
STEAM CLEAN HEAVY GREASE	C	8650	19340
LIGHT GREASE	D	5050	13470

DATA SOURCE	OCCUPATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
NAA	503	MAA	SCLPCXX	SCLCDXX	VARIABLE	COMPONENT(S),DEGREASE STARTS-WITH REACH TO GET GOGGLES INCLUDES-ALL THE MOTIONS NECESSARY TO GET AND PUT ON GOGGLES AND GLOVES,PUT PART/BASKET ON PLATFORM AND STEP UP ON PLATFORM,GET ROLLER, ROLL TANK COVER BACK,MOVE NOZZLE ASIDE AND CONTINUE TO ROLL COVER BACK,REPLACE NOZZLE, STEP TO HOOK,GET HOOK,GET PART OR BASKET AND PLACE ON HOOK,LIFT PART OR BASKET AND STEP TO DEGREASER,LOWER PART OR BASKET INTO DEGREASER,REMOVE HOOK FROM PART OR BASKET AND RAISE HOOK FROM TANK,ASIDE HOOK,CLOSE TANK COVER(MOVE ASIDE AND REPLACE NOZZLE), MOVE TO PLATFORM STEPS,STEP DOWN AND TURN FROM STEPS,TAKE OFF GOGGLES AND GLOVES, ASIDE,GET AND PUT ON GOGGLES AND GLOVES,TURN TO PLATFORM,CLIMB STEPS TO PLATFORM,OPEN COVER AND GET HOOK,HOOK PART OR BASKET IN DEGREASER AND REMOVE FROM TANK,LOWER PART OR BASKET TO FLOOR,REMOVE AND ASIDE HOOK,GET PART OR BASKET AND STEP DOWN FROM PLATFORM,ASIDE PART OR BASKET ENDS-WITH ASIDE PART OR BASKET CONDITIONS-PLACE ADDITIONAL PARTS OR BASKETS ON PLATFORM IS NOT INCLUDED-SPRAYING AND WALKING TO GET PARTS AND EQUIPMENT IS NOT INCLUDED
					3196	CASE 01 DEGREASE-FIRST PART OR BASKET OF PARTS-40 POUNDS
					436	02 EACH ADDITIONAL PART OR BASKET OF PARTS-40 POUNDS
					2447	03 DEGREASE PART OVER 40 POUNDS-TWO MEN PLACE PART/BASKET ON CART AND MOVE CART TO HOIST AND RETURN PART/BASKET TO WORK BENCH-FIRST PART OR BASKET-HOIST TIME NOT INCLUDED
					733	04 DEGREASE PART OVER 40 POUNDS-TWO MEN-EACH ADDITIONAL PART-HOIST TIME NOT INCLUDED
NAA	503	MAA	SCLPDTX	SCLDPXX	VARIABLE	PART,DIP TO CLEAN STARTS-WITH TURN TO BATH INCLUDES-ALL THE MOTIONS NECESSARY TO TURN AND REACH TO BATH LID HANDLE,RAISE LID AND GET BASKET OUT OF BATH,PLACE BASKET ON RAIL,GET PART FROM CART AND PLACE IN BASKET,LIFT BASKET FROM RAIL AND LOWER INTO VAT,LOWER LID,OPEN VAT LID,REMOVE BASKET WITH PART(S)FROM VAT, POSITION BASKET ON RAIL,DRAIN PARTS,GET PART AND PLACE ON GRILLE IN SPRAY BOOTH,RETURN BASKET TO VAT AND CLOSE LID ENDS-WITH CLOSE VAT LID CONDITIONS-ENW OF PART AND BASKET IS 10 POUNDS-DOES NOT INCLUDE WALKING TO AND FROM CART,TO AND FROM SPRAY BOOTH OR VAT TIME-DIP IS TURCO-CARB SOLUTION-OR EQUAL-NO DRAIN TIME INCLUDED
					554	CASE 01 DIP FIRST PART
					111	02 DIP EACH ADDITIONAL PART

DEFENSE WORK MEASUREMENT STANDARD TIME DATA ELEMENTS

DATA SOURCE	OCCUPATION	QUALITY	SOURCE CODE	DWNSTOP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
NAA	503	MAA	SCLPOT3	SCLOP03	1240	PART,DIP TO CLEAN STARTS-WITH TURN TO VAT INCLUDES-ALL THE MOTIONS NECESSARY TO TURN TO VAT,OPEN LID,REMOVE LARGE BASKET AND POSITION BASKET ON RAIL,PICK UP SMALL BASKET FROM STACK AND PLACE ON CART,GET CONTAINER OF SMALL PARTS AND DUMP PARTS INTO BASKET,ASIDE CONTAINER, PLACE SMALL BASKET IN LARGE BASKET,LIFT FROM RAIL AND LOWER INTO VAT,CLOSE LID,OPEN VAT LID,REMOVE BASKET OF PARTS,POSITION BASKET ON RAIL AND DRAIN,ASIDE PARTS TO SPRAY BOOTH GRILLE(SMALL BASKET),RETURN LARGE BASKET TO VAT,CLOSE LID,REMOVE PARTS FROM SMALL BASKET AND ASIDE BASKET TO STORAGE ENDS-WITH ASIDE BASKET CONDITIONS-ENW OF LARGE BASKET IS 10 POUNDS-SMALL BASKET WITH PARTS WEIGHS TO 10 POUNDS-DOES NOT INCLUDE WALKING TO GET SMALL BASKET, FROM CART TO TANK AND RETURN OR TO AND FROM BOOTH-NO TANK TIME IS INCLUDED-DIP SOLUTION IS TURCO-CARB OR EQUAL-NO DRAIN TIME INCLUDED
NAA	503	FUA	CPLPC03	SCLHV01	16792	HARDWARE,VACU-BLAST STARTS-WITH REACH TO GET BUSS BARS(TWO) INCLUDES-ALL THE MOTIONS NECESSARY TO GET TWO BUSS BARS,TWO ANODES AND FIVE HANGERS AND PLACE IN VACU-BLAST,ACTUATE VACU-BLAST AND BLAST PARTS(HARDWARE)TO ASSURE GOOD ELECTRICAL CONTACT,GET AND ASIDE TWO ANODES AND FIVE HANGERS TO BENCH,GET BUSS BARS AND POSITION ON PLATING TANK ENDS-WITH BUSS BARS IN POSITION ON TANK CONDITIONS-DOES NOT INCLUDE WALK TO GET HARDWARE OR WALK TO AND FROM VACU-BLAST-15540 TMUS PROCESS(VACU-BLAST)TIME IS INCLUDED
NAA	503	TUA	OCL9AXX	SCLP8XX	VARIABLE	PART,BLAST(ABRASIVE)IN BOOTH STARTS-WITH REACH TO OBJECT TO BE BLASTED INSIDE BOOTH INCLUDES-ALL THE MOTIONS NECESSARY TO REACH AND POSITION OBJECT IN BOOTH,OBTAIN NOZZLE, OPEN CONTROL VALVE,REMOVE CONTAMINATION FROM OBJECT,CLOSE CONTROL VALVE,SHAKE PART TO REMOVE EXCESS ABRASIVE,ASIDE PART IN BOOTH ENDS-WITH ASIDE PART CONDITIONS-CLEAN PARTS TO FIVE SQUARE FEET-PER SQUARE FOOT BLASTED(12 INCHES X 12 INCHES)-SEED OR GARNET ABRASIVE-INCLUDES PRORATED ADDITION OF ABRASIVE MATERIAL TO BOOTH-SIMPLE SURFACE IS DEFINED AS READILY ACCESSIBLE REQUIRING LITTLE OR NO REPOSITIONING DURING CLEANING-COMPLEX SURFACE IS DEFINED AS SURFACE HAVING SOME RECESSED,RESTRICTED OR DIFFICULT ACCESS AREAS REQUIRING REPOSITIONING OF THE OBJECT DURING CLEANING(PANGBORN REACH-IN BOOTH) 259 CASE 01 BLAST SQUARE FOOT-SIMPLE SURFACE 383 02 BLAST SQUARE FOOT-COMPLEX SURFACE

DATA SOURCE	OCCUPATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
FFF	503	FUA	RLGCSB1	SCLPB03	3478	PARTS,BLAST CLEAN WITH GLASS=VERY SMALL PARTS STARTS=WITH REACH TO PARTS BASKET INCLUDES=ALL THE MOTIONS NECESSARY TO GET PARTS BASKET FROM CLEANING BASKET,TURN TO BLAST CABINET,OPEN DOOR AND PLACE PARTS BASKET ON TURNTABLE,MOVE TO FRONT OF CABINET AND TURN BLAST MACHINE ON,PUT HANDS INTO GLOVES,PLACE PARTS BASKET AND NOZZLE IN WORK POSITION,ACTUATE FOOT LEVER TO BLAST,BLAST CLEAN BASKET OF PARTS,REMOVE FOOT FROM LEVER, ASIDE NOZZLE AND PARTS BASKET,MOVE HANDS OUT OF GLOVES,TURN BLAST MACHINE OFF,MOVE TO BLAST CABINET DOOR,OPEN,GET PARTS BASKET,CLOSE DOOR, ASIDE BASKET OF PARTS INTO CLEAN BASKET ENDS=WITH ASIDE PARTS BASKET CONDITIONS=BASKET IS CONSTRUCTED OF STEEL SCREEN,1/8 INCH MESH=DIMENSIONS ARE FOUR X SIX X THREE INCHES=DOES NOT INCLUDE WALKING WITH PARTS TO AND FROM CABINET=BLAST TIME OF 2816 TMUS INCLUDED
FFF	503	FUA	RLGCSB2	SCLP904	2922	PARTS,BLAST CLEAN WITH GLASS=SMALL PARTS STARTS=WITH REACH TO PICK UP PARTS INCLUDES=ALL THE MOTIONS NECESSARY TO PICK UP PARTS(FOUR)FROM CLEANING BASKET,OPEN BLAST CABINET DOOR,PLACE PARTS ON TURNTABLE,CLOSE DOOR,TURN TO FRONT OF CABINET,TURN ON BLAST MACHINE,MOVE HANDS INTO GLOVES,POSITION NOZZLE AND PARTS TO WORK POSITIONS,ACTUATE FOOT LEVER TO BLAST,BLAST CLEAN ONE SMALL PART,REMOVE FOOT FROM LEVER,ASIDE NOZZLE AND PART,PULL HANDS OUT OF GLOVES,TURN BLAST MACHINE OFF, OPEN CABINET,PICK UP PARTS,CLOSE DOOR,PLACE PARTS IN CLEANING BASKET ENDS=WITH ASIDE PARTS CONDITIONS=FOUR SMALL PARTS ARE PLACED IN BLAST CABINET AT ONE TIME,ELEMENT TIME IS TO CLEAN ONE PART=BLAST TIME OF 2618 TMUS IS INCLUDED
FFE	503	FUA	IOFTFKA	SCLPC01	3634	PART,CLEAN WITH SOLVENT IN SPRAY BOOTH STARTS=WITH GET OBJECT FROM CART INCLUDES=ALL THE MOTIONS NECESSARY TO GET OBJECT FROM CART PARKED AT SPRAY BOOTH,OBTAIN AND PUT ON FACE SHIELD AND RUBBER GLOVES,TURN ON SPRAY,MOVE HOSE BACK AND FORTH OVER OBJECT TO CLEAN,TURN OFF SPRAY,GET COMPRESSED AIR HOSE AND AIR DRY OBJECT,ASIDE HOSE,GET AND ASIDE OBJECT TO CART ENDS=WITH OBJECT ASIDE CONDITIONS=OBJECT WEIGHS 30 TO 40 POUNDS=CLEAN UP TO 110 SQUARE INCHES OF SURFACE AREA=DOES NOT INCLUDE GETTING AND LOADING CART PRIOR TO PLACING OBJECTS IN SPRAY BOOTH=DOES NOT INCLUDE PUSHING TO OR FROM SPRAY BOOTH=ELEMENT TIME IS BASED ON 10 PARTS PER CART LOAD=2500 TMUS PROCESS TIME INCLUDED

DEFENSE WORK MEASUREMENT STANDARD TIME DATA ELEMENTS

DATA SOURCE	OCCUPATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
NAA	503	FUA	SCLUC01	SCLPC02	6235	PARTS,CLEAN(ULTRASONIC) STARTS-WITH REACH TO GET BASKET INCLUDES-ALL THE MOTIONS NECESSARY TO GET BASKET,OPEN CLEANER DOOR,PLACE BASKET IN WELL, SET TIMER,OPEN DOOR,PUSH ON PUMP SWITCH,MOVE FOOT TO RINSE CONTROL,ACTUATE RINSE CONTROL, RINSE PARTS,REMOVE FOOT FROM RINSE CONTROL, REMOVE BASKET(LARGE)FROM WELL AND ASIDE TO TOP,REMOVE SMALL BASKET OF PARTS,ASIDE,REPLACE LARGE BASKET IN CLEANER,PUSH PUMP SWITCH OFF, CLOSE CLEANER DOOR,GET SMALL BASKET OF PARTS, TURN FROM CLEANER AND ASIDE AT WORKPLACE ENDS-ASIDE BASKET(SMALL) CONDITIONS-BASKET AND PARTS WEIGH TO 20 POUNDS-WALKING TO GET PARTS AND EQUIPMENT NOT INCLUDED-APPLIES TO BLACKSTONE ULTRASONIC CLEANER,ULTRASONIC VAPOR RINSE, SN-104,MODEL NUMBER V.R.-10 SPECIAL OR EQUIVALENT-CLEANING TIME NOT INCLUDED-5500 TMUS RINSE TIME IS INCLUDED
FFE	503	FUA	DIGCG07	SCLPC03	6991	PART,CLEAN IN ULTRASONIC CLEANING VAT STARTS-WITH REACH TO HEATER SWITCH INCLUDES-ALL THE MOTIONS NECESSARY TO TURN HEATER AND PULSE SWITCHES ON,GRASP HANDLE AND RAISE VAT COVER,GET PART AND PLACE IN VAT, GET VAT COVER HANDLE AND CLOSE COVER,TURN HEATER AND PULSE SWITCHES OFF,OPEN VAT COVER, GET PART AND PLACE ON TANK DRAIN,CLOSE VAT COVER ENDS-WITH VAT COVER CLOSED CONDITIONS-COVER AND PART WEIGH 10 POUNDS EACH-FOUR MINUTES(6668 TMUS)CLEANING TIME INCLUDED
FFE	503	TUA	IAETP05	SCLPC04	3483	PART OR BASKET OF PARTS,CLEAN AND DRY-SPRAY BOOTH STARTS-WITH REACH TO HOSE INCLUDES-ALL THE MOTIONS NECESSARY TO GET HOSE TO WORK AREA,ACTUATE TRIGGER(THREE TIMES ON AND THREE TIMES OFF),SPRAY PART(S)WITH SOLVENT AND DRY,RELEASE HOSE ENDS-WITH RELEASE OF HOSE
FFE	503	TUA	IAECG03	SCLPD01	4238	PART(OR BASKET OF PARTS),DEGREASE STARTS-WITH REACH TO LID TO OPEN INCLUDES-ALL THE MOTIONS NECESSARY TO GET AND OPEN DEGREASER LID,GET HOOK HANGING IN DEGREASER,ATTACH HOOK TO PART OR TO BASKET HANDLE,MOVE HOOK OVER DEGREASER,LOWER PART OR BASKET ON HOOK INTO DEGREASER,SOLVENT CLEAN PART(S)AND DRY,REMOVE PART(S)FROM DEGREASER, CLOSE LID,GET HOOK AND REMOVE PART OR BASKET FROM HOOK,PLACE HOOK IN DEGREASER ENDS-WITH RETURN HOOK TO DEGREASER CONDITIONS-LID WEIGHS 10-20 POUNDS-PART(S) WEIGH 10-20 POUNDS-WALK TO AND FROM TANK NOT INCLUDED-PROCESS TIME TO GET HOSE AND SPRAY PART(3483 TMUS)IS INCLUDED

DEFENSE WORK MEASUREMENT STANDARD TIME DATA ELEMENTS

DATA SOURCE	OCCUPATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
FFE	503	MAA	DITITKJ	SCLPD02	2023	PARTS(IN BASKET),DIP RINSE AFTER SONIC CLEAN STARTS-WITH REACH TO SONIC CLEANER LID HANDLE INCLUDES-ALL THE MOTIONS NECESSARY TO OPEN SONIC CLEANER LID,REMOVE BASKET OF PARTS,DRAIN BASKET OF PARTS,PLACE BASKET ON ADJOINING TANK OR BENCH,CLOSE SONIC CLEANER LID,PICK UP BASKET OF PARTS AND PLACE NEAR RINSE TANK,OPEN RINSE TANK LID, PLACE BASKET OF PARTS IN FLUID AND AGITATE,REMOVE FROM FLUID,SET DOWN NEAR TANK,CLOSE RINSE TANK LID ENDS-WITH RINSE TANK LID CLOSED CONDITIONS-BASKET OF PARTS WEIGHS 10 TO 20 POUNDS-LIDS 2.5 TO 10 POUNDS-WALK TO CLEANER TANK AND BETWEEN CLEANER AND RINSE TANK NOT INCLUDED
FFE	503	MAA	IOFEGKD	SCLPR01	2059	PARTS(IN BASKET),RINSE STARTS-WITH REACH TO HANDLES OF BASKET INCLUDES-ALL THE MOTIONS NECESSARY TO GRASP AND RAISE FOLDED HANDLES OF BASKET,RAISE BASKET FROM CLEANER TANK,TILT BASKET TO DRAIN, PLACE BASKET ON EDGE OF TANK,GET RINSE TANK DRAIN PLUG AND SEAT IN DRAIN HOLE,ARISE,GET BASKET OF PARTS AND PLACE IN RINSE TANK,LOWER TANK LID,TURN ON SWITCH,TURN OFF SWITCH,RAISE LID,GET BASKET HANDLES AND MOVE BASKET IN FLUID TO AGITATE,REMOVE BASKET FROM FLUID, DRAIN,PLACE BASKET ON EDGE OF TANK,GET DRAIN PLUG AND REMOVE FROM DRAIN HOLE,POSITION SPLINE ON DRAIN,ARISE ENDS-WITH ARISE FROM BEND CONDITIONS-BASKET OF PARTS HAS ENW OF 20 POUNDS-LID HAS ENW OF 10 POUNDS
FFE	503	MAA	IOFEGKJ	SCLPR02	1158	PARTS(IN BASKET),RINSE(DIP) STARTS-WITH REACH TO GET BASKET OF PARTS INCLUDES-ALL THE MOTIONS NECESSARY TO PICK UP BASKET,AND PLACE ON ADJOINING TANK,RAISE RINSE TANK LID,GET BASKET OF PARTS,PLACE IN FLUID AND MOVE BASKET IN FLUID TO AGITATE,REMOVE BASKET FROM FLUID,PLACE BASKET ON ADJOINING TANK,LOWER RINSE TANK LID,RELEASE LID ENDS-WITH RELEASE RINSE TANK LID-CLOSED CONDITIONS-DOES NOT INCLUDE WALK WITH BASKET TO RINSE TANK-ENW OF BASKET OF PARTS IS 20 POUNDS-ENW OF TANK LID IS 10 POUNDS-AGITATE FLUID WITH SIX MOVES(SIX INCHES EACH)
AF	503	MAF	76	MDPPD01	223	PART,DIP IN SOLVENT TO CLEAN,WEIGHT-LESS THAN 2.5 POUNDS STARTS-WITH PART IN HAND INCLUDES-ALL MOTIONS NECESSARY TO MOVE PART INTO SOLVENT,SWISH PART BACK AND FORTH TO CLEAN,REMOVE PART FROM SOLVENT,AND SHAKE TO REMOVE SOLVENT AND DRY ENDS-WITH PART IN HAND
FFE	503	MAA	IOFEGKH	MJPPP01	167	PARTS(IN BASKET),PLACE IN CLEANING TANK STARTS-WITH BASKET HANDLES IN HAND INCLUDES-ALL THE MOTIONS NECESSARY TO MOVE BASKET OF PARTS OVER TANK,LOWER TO BOTTOM ENDS-WITH BASKET AT BOTTOM OF TANK CONDITIONS-ENW OF BASKET OF PARTS IS 20 POUNDS

DEFENSE WORK MEASUREMENT STANDARD TIME DATA ELEMENTS

DATA SOURCE	OCCUPATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
FFE	503	MAA	RLGJPB7	SJPBP01	2183	BLAST CLEAN,PREPARE(AGACITE OR AIR HONE) STARTS-WITH REACH TO SLIDING DOOR INCLUDES-ALL THE MOTIONS NECESSARY TO OPEN BLAST BOOTH DOOR,AND ENTER BOOTH,CLOSE DOOR, WALK TWO PACES IN BOOTH,WALK SIX PACES TO BASKET ENTRY DOOR,RAISE DOOR,GET BASKET OF PARTS,PLACE BASKET ON TURNTABLE,MAKE DIRECTION CHANGE OF TURNTABLE,CLOSE ENTRY DOOR,PUT ON HOOD AND GLOVES,TURN BLAST MACHINE ON AND OFF, WALK FIVE PACES TO BASKET EXIT DOOR,PUSH DOOR UP,GET BASKET OF PARTS,PLACE ON CONVEYOR AND PUSH OUT BOOTH,CLOSE EXIT DOOR,WALK TWO PACES TO BOOTH DOOR AND OPEN DOOR,STEP OUT OF BOOTH AND CLOSE DOOR ENDS-WITH CLOSE BOOTH DOOR
FFE	503	MAA	OIGCCJI	SJPCLXX	VARIABLE	CLEANER(COREHN),LOAD/UNLOAD(SMALL PART) STARTS-WITH REACH TO HOLDER INCLUDES-ALL THE MOTIONS NECESSARY TO POSITION HOLDER,GET TWEEZERS,PICK UP PART(SMALL)AND PLACE ON HOLDER,ASIDE TWEEZERS,GET AND PLACE HOLDER WITH PART IN CLEANER,TURN ON CLEANER, TURN OFF DRYER,REMOVE HOLDER FROM CLEANER,GET TWEEZERS,REMOVE AND ASIDE PART FROM HOLDER, ASIDE TWEEZERS ENDS-WITH ASIDE TWEEZERS 349 CASE 01 LOAD AND UNLOAD FIRST PART 81 02 LOAD AND UNLOAD EACH ADDITIONAL PART UP TO CAPACITY OF HOLDER
FFE	503	MAA	IOFEGKA	SJPCL03	532	CLEANER(SONIC),LOAD STARTS-WITH REACH TO GET BASKET OF PARTS INCLUDES-ALL THE MOTIONS NECESSARY TO PICK UP A BASKET OF PARTS,PLACE BASKET ON LID OF RINSE TANK,OPEN CLEAN LID,GET BASKET AND PLACE IN CLEANER,LOWER BASKET TO BOTTOM OF TANK,CLOSE TANK LID,SET TIMER ENDS-WITH TIMER SET CONDITIONS-DOES NOT INCLUDE WALKING WITH BASKET TO CLEAN-INCLUDES NECESSARY WALKING AT CLEANER TO MOVE BETWEEN LID AND BASKET-BASKET OF PARTS HAS ENW OF 20 POUNDS-LID HAS ENW OF 10 POUNDS
FFE	503	MAA	IOFEGKI	SJPCU01	865	CLEANER(SONIC),UNLOAD(BASKET) STARTS-WITH REACH TO CLEANER LID INCLUDES-ALL THE MOTIONS NECESSARY TO RAISE CLEANER LID,GET AND RAISE BASKET HANDLES,MOVE BASKET IN FLUID TO AGITATE,REMOVE BASKET FROM FLUID,PLACE BASKET ON LID OF ADJOINING TANK, LOWER CLEANER LID,RELEASE LID ENDS-WITH RELEASE LID CONDITIONS-ENW OF BASKET PARTS IS 20 POUNDS, ENW OF LID IS 10 POUNDS
FFE	503	MAA	IOFEGKF	SJPDU01	414	DRYER,UNLOAD STARTS-WITH REACH TO DRYER SWITCH INCLUDES-ALL THE MOTIONS NECESSARY TO TURN OFF DRYER SWITCH,RAISE DRYER LID,GET AND RAISE FOLDED HANDLES ON BASKET OF PARTS,REMOVE BASKET OF PARTS FROM DRYER,PLACE BASKET ON RINSE TANK LID,CLOSE DRYER LID,GET BASKET FROM DRYER LID AND PLACE ON WORKBENCH ENDS-WITH ASIDE BASKET OF PARTS ON WORKBENCH CONDITIONS-DOES NOT INCLUDE WALKING TO DRYER AND FROM DRYER TO WORKBENCH-DOES INCLUDE MOVES NECESSARY TO ASIDE BASKET,CLOSE LID AND GET BASKET AGAIN-BASKET OF PARTS HAS ENW OF 20 POUNDS-DRYER LID HAS ENW OF 10 POUNDS

DATA SOURCE	OCCUPATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
MF	503	MAP	3236	SJPMP01	470	HELMET(SANDBLAST),PUT ON AND REMOVE STARTS-WITH REACH TO HELMET INCLUDES-ALL MOTIONS NECESSARY TO GET HELMET, GET CLOTH FROM POCKET,WIPE VISION PORT,RETURN CLOTH TO POCKET,PLACE HELMET OVER HEAD,FASTEN WAIST BUCKLE,FASTEN CHEST BUCKLE,ADJUST CLOTH BIB;UNSNAP WAIST BUCKLE,UNSNAP CHEST BUCKLE, AND REMOVE,BEND AND RELEASE HELMET ON FLOOR, ARISE ENDS-WITH ARISE FROM BEND
FFE	503	MAA	01GCG03	SJPOSXX	VARIABLE	OBJECTS,STRING ON WIRE FOR CLEANING STARTS-WITH REACH TO GET DYKES INCLUDES-ALL THE MOTIONS NECESSARY TO GET DYKES AND CUT LENGTH OF WIRE FROM ROLL,ASIDE DYKES,GET AND PLACE OBJECT OVER WIRE,PULL WIRE OVER OBJECT AND PULL SNUG,GET TWO ENDS OF WIRE AND TWIST OBJECT AND WIRE TO SECURE,PLACE STRING OVER ARM,PLACE STRING OF OBJECTS ON BENCH ENDS-WITH STRING OF OBJECTS ASIDE CONDITIONS-OBJECTS WEIGH 2.5 TO 10 POUNDS-DOES NOT INCLUDE WALKING TO GET OBJECTS,WIRE OR TO BENCH TO ASIDE STRING 561 CASE 01 STRING FIRST OR ONLY OBJECT 223 02 STRING EACH ADDITIONAL OBJECT
FFF	503	MAA	GJPPCA1	SJPPC01	643	PREPARATION,MAKE FOR CLEANING PARTS IN SPRAY BOOTH STARTS-WITH REACH TO FACE SHIELD INCLUDES-ALL MOTIONS NECESSARY TO GET AND PUT ON FACE SHIELD,GET AND PUT ON CLOSE FITTING RUBBER GLOVES,AND TURN FAN SWITCH ON;AND TURN FAN SWITCH OFF,REMOVE AND ASIDE GLOVES,AND REMOVE AND ASIDE FACE SHIELD ENDS-WITH RELEASE OF FACE SHIELD
FFE	503	MAA	IOTEGKC	SJPPM01	1234	PARTS(IN BASKET),MOVE FROM SONIC CLEANER TO RINSE TANK STARTS-WITH GET HANDLE OF RINSE TANK LID INCLUDES-ALL THE MOTIONS NECESSARY TO RAISE RINSE TANK LID,GET AND OPEN SONIC CLEANER LID,REACH AND GET HANDLES(SIMO)OF BASKET OF PARTS,RAISE HANDLES,MOVE BASKET FOUR TIMES IN FLUID TO AGITATE,REMOVE BASKET FROM SONIC CLEANER,PLACE ON TANK RIM,DRAIN PARTS,PLACE BASKET INTO RINSE TANK,FOLD HANDLES(SIMO),GET RINSE TANK LID HANDLE AND CLOSE LID,TURN ON RINSE SWITCH,TURN OFF SWITCH,GET RINSE TANK LID HANDLE AND OPEN LID ENDS-WITH LID OPEN,HAND ON HANDLE CONDITIONS-DOES NOT INCLUDE WALKING TO RINSE TANK OR RETURN TO WORKBENCH-WALKING OR SIDE-STEPS BETWEEN TANKS IS INCLUDED(THREE SIDE-STEPS)-BASKET OF PARTS ENW IS 20 POUNDS-LIDS ENW IS 10 POUNDS
FFE	503	MAA	IOTEGKE	SJPPP01	228	PARTS(IN BASKET),PLACE IN DRYER STARTS-WITH REACH TO DRYER LID INCLUDES-ALL THE MOTIONS NECESSARY TO GET LID HANDLE AND OPEN DRYER LID,GET BASKET OF PARTS, AND PLACE IN DRYER,FOLD BASKET HANDLES(SIMO), GET LID HANDLE AND CLOSE LID,REACH AND TURN ON DRYER ENDS-WITH TURN ON DRYER SWITCH CONDITIONS-DOES NOT INCLUDE WALKING TO RINSE TANK,DRYER,BETWEEN TANK AND DRYER OR RETURN TO WORKBENCH-ENW OF BASKET OF PARTS IS 20 POUNDS-ENW OF LID IS 10 POUNDS

DEFENSE WORK MEASUREMENT STANDARD TIME DATA ELEMENTS

DATA SOURCE	OCCUP-ATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
NAA	504	MAA	SPLPH01	SOMPR01	1109	PART,BAKE STARTS-WITH REACH TO GET GLOVES INCLUDES-ALL THE MOTIONS NECESSARY TO GET AND PUT ON GLOVES,OPEN OVEN DOOR,GET PART AND PUT IN OVEN,CLOSE OVEN DOOR,REMOVE AND ASIDE GLOVES,GET AND PUT ON GLOVES,OPEN OVEN DOOR, REMOVE PART FROM OVEN AND ASIDE,CLOSE OVEN DOOR,REMOVE AND ASIDE GLOVES,GET PENCIL FROM POCKET HOLDER,RECORD TIME OUT OF OVEN,RETURN PENCIL TO POCKET ENDS-WITH PENCIL RETURNED TO POCKET CONDITIONS-PART WEIGHS TO 30 POUNDS-DOES NOT INCLUDE PROCESS(BAKE)TIME
NAA	505	MAA	JACM001	SSTSC01	679	SURFACE(METAL),COAT AND RINSE STARTS-WITH REACH TO WATER HOSE INCLUDES-ALL THE MOTIONS NECESSARY TO GET WATER HOSE,MOVE HOSE TO SURFACE TO BE RINSED AND MOVE OVER SURFACE TO COVER(FOUR MOVES) ASIDE WATER HOSE,GET BRIGHT DIP HOSE AND MOVE TO WORK,MOVE OVER SURFACE(FOUR TIMES)TO COVER, ASIDE BRIGHT DIP HOSE,GET WATER RINSE HOSE AND RINSE OFF BRIGHTENER(DIFFICULT TO REMOVE-MOVE HOSE NINE TIMES OVER SURFACE),ASIDE HOSE,GET ALODINE SPRAY HOSE,MOVE TO SURFACE,MOVE SPRAY (NINE TIMES)OVER SURFACE TO AGITATE,ASIDE HOSE AND GET RINSE WATER HOSE,RINSE OFF ALODINE WITH FOUR MOVES OVER SURFACE,ASIDE HOSE ENDS-WITH ASIDE ALODINE RINSE HOSE CONDITIONS-DOES NOT INCLUDE WALK TO GET AND RETURN WITH HOSE
NAA	549	MAA	NOYCC02	MCLCC01	1537	CYLINDER(COMPRESSED GAS-EMPTY),CONNECT TO VACUUM MACHINE STARTS-WITH REACH TO CYLINDER VALVE INCLUDES-ALL THE MOTIONS NECESSARY TO GRASP AND PULL VALVE THROUGH HOLE IN OVEN DOOR,GET VACUUM HOSE AND CONNECT TO CYLINDER VALVE,OPEN CYLINDER VALVE,OPEN HOSE VALVE,TURN ON VACUUM PUMP,TURN ON OVEN,CHECK VACUUM READING FOUR TIMES,TURN OFF ALL VALVES,VACUUM PUMP AND OVEN ENDS-WITH ALL VALVES,PUMP AND OVEN OFF CONDITIONS-CYLINDER IS IN OVEN AT START AND END-DOES NOT INCLUDE WALKING TO AND FROM OVEN TO CHECK OPERATION-DOES NOT INCLUDE PROCESS TIME TO PUMP DOWN VACUUM
NAA	549	MUA	NOYCC02	SCLCP01	3242	CYLINDER(COMPRESSED GAS),PURGE WITH OXYGEN STARTS-WITH REACH TO GET TOOL INCLUDES-ALL THE MOTIONS NECESSARY TO GET TOOL AND REMOVE SAFETY CAP FROM CYLINDER VALVE, REACH AND GET PURGE HOSE,CONNECT TO VALVE,OPEN VALVE ON CYLINDER,OPEN MANIFOLD VALVE,PURGE CYLINDER WITH OXYGEN,CLOSE CYLINDER AND MANI-FOLD VALVE,DISCONNECT AIR HOSE FROM VALVE, ASIDE HOSE,GET TOOL AND SAFETY CAP,INSTALL CAP AND TIGHTEN,ASIDE TOOL,ASIDE CYLINDER ENDS-WITH ASIDE CYLINDER CONDITIONS-EMPTY CYLINDER WEIGHS TO 50 POUNDS-PROCESS TIME TO PURGE IS 600 TMUS

DATA SOURCE	OCCUPATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
NAA	549	MAA	NOYCR03	SDACDXX	VARIABLE	CYLINDER(COMPRESSED GAS),DISASSEMBLE(AUTOMATIC WRENCH/HAND WRENCH) STARTS-WITH PLACE CYLINDER IN VISE INCLUDES-ALL THE MOTIONS NECESSARY TO GET CYLINDER,GET WRENCH AND PLACE ON VALVE,REMOVE VALVE,ASIDE TOOL,INSPECT VALVE AND CYLINDER INTERIOR WITH FLASHLIGHT,REMOVE CYLINDER FROM VISE AND ASIDE ENDS-WITH ASIDE CYLINDER CONDITIONS-CYLINDER WEIGHS TO 20 POUNDS
					2071	CASE 01 DISASSEMBLE WITH AUTOMATIC WRENCH-PROCESS TIME(AUTO WRENCH)-200 TMUS INCLUDED
					2371	02 DISASSEMBLE WITH HAND WRENCH
NAA	549	TUA	NOYCT02	MVSCC01	758	CYLINDER(COMPRESSED GAS),CLAMP IN VISE STARTS-WITH REACH TO VISE PIN INCLUDES-ALL THE MOTIONS NECESSARY TO GRASP, REMOVE AND ASIDE VISE PIN,SWING VISE PIN OPEN, WALK 10 FEET TO CYLINDER STORAGE,GET CYLINDER AND ROLL 10 FEET INTO VISE,SWING VISE SECTION CLOSED,REPLACE PIN IN VISE,TIGHTEN VISE ENDS-WITH HAND ON VISE HANDLE CONDITIONS-CYLINDER OVER 30 POUNDS
NAA	549	MAA	NOYVQ01	MVSVD01	76	VISE(SPECIAL CYLINDER),OPEN OR CLOSE STARTS-WITH REACH TO VISE HANDLE INCLUDES-ALL THE MOTIONS NECESSARY TO GRASP HANDLE AND LOOSEN OR TIGHTEN(AVERAGE DISTANCE OF 1/2 INCH)BY TURNING HANDLE,RELEASE HANDLE ENDS-WITH RELEASE HANDLE
FFE	599	MAA	OIGSRL3	MCLPRXX	VARIABLE	PART,RINSE WITH PRESSURE SPRAY STARTS-WITH PART IN HAND INCLUDES-ALL THE MOTIONS NECESSARY TO MOVE PART TO TANK,HOLD PART AND TURN DURING RINSE TO COVER ALL SURFACES,SHAKE PART TO REMOVE RESIDUE AFTER RINSE,LAY PART ASIDE ENDS-WITH HAND ON PART CONDITIONS-NO WALKING INCLUDED
					288	CASE 01 PART-2.5 TO 10 POUNDS
					228	02 PART-LESS THAN 2.5 POUNDS
FFD	599	TBA	GECCHSX	MCLPSXX	VARIABLE	PARTS,STEAM CLEAN(PROCESS TIME) STARTS-WITH STEAM VALVE OPEN,NOZZLE IN HAND INCLUDES-ALL THE TIME AND MOTIONS NECESSARY TO STEAM PART,RACK OR BASKET OF PARTS ENDS-WITH STEAM VALVE OPEN
					5377	CASE 01 RACK OF PARTS,PERFORATED PLATE OR SIX HOOK RACK LOADED WITH PARTS
					1445	02 MEDIUM PART
					3750	03 LARGE PART
					8217	04 VERY LARGE PART
					5327	05 LARGE BASKET OF PARTS-1 1/2 X 3 1/2 X 3 1/2 TO 2 X 4 X 4 FEET
					3925	06 MEDIUM BASKET OF PARTS-5 X 17 X 27 TO 8 X 18 X 61 INCHES

DATA SOURCE	OCCUPATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
MAA	599	MAA	SCLCC44	SCLCCXX	VARIABLE	COMPONENT,CLEAN WITH VACUUM STARTS-WITH REACH TO VACUUM HOSE INCLUDES-ALL THE MOTIONS NECESSARY TO GET HOSE AND TURN VACUUM ON,UNCOIL VACUUM HOSE,GET EXTENSION,CONNECT EXTENSION,VACUUM SURFACE TO REMOVE WATER AND LOOSE PAINT,DISCONNECT EXTENSION,ASIDE EXTENSION,COIL AND ASIDE HOSE, TURN VACUUM OFF ENDS-WITH HOSE COILED AND VACUUM OFF CONDITIONS-COMPLEX,AN AREA WITH OBSTRUCTIONS SUCH AS RIBS,FORMERS,ETC.,BUT ACCESSIBLE-VERY COMPLEX-OBSTRUCTED AREA CLEANED THROUGH AN OPENING SUCH AS ACCESS OR INSPECTION DOORS-APPLIES TO INVISIBLE VACUUM,TYPE AC,MODEL 8098-WALK TO GET HOSE AND EXTENSION NOT INCLUDED
					2166	CASE 01 VACUUM COMPLEX SURFACE-FIRST SQUARE FOOT
					449	02 VACUUM COMPLEX SURFACE-EACH ADDITIONAL SQUARE FOOT
					2606	03 VACUUM VERY COMPLEX SURFACE-FIRST SQUARE FOOT
					661	04 VACUUM VERY COMPLEX SURFACE-EACH ADDITIONAL SQUARE FOOT
FFE	599	MAA	OIGSRL4	SCLP9XX	VARIABLE	PART,BRUSH OFF PAINT IN THINNER STARTS-WITH REACH TO GET PART INCLUDES-ALL THE MOTIONS NECESSARY TO GET PART AND HOLD IN THINNER,GET LARGE BRUSH AND BRUSH PART IN THINNER WITH PRESSURE,ASIDE LARGE BRUSH AND GET SMALL BRUSH,BRUSH REMAINING AREA,ASIDE SMALL BRUSH AND GET RAG,WIPE PART DRY AND ASIDE RAG,INSPECT PART(VISUAL),ASIDE PART ENDS-WITH ASIDE PART CONDITIONS-PAINT REMOVER HAS BEEN APPLIED PRIOR TO THIS OPERATION
					1493	CASE 01 PART-2.5 TO 10 POUNDS
					1057	02 PART-LESS THAN 2.5 POUNDS
FFE	599	MAA	OIGCH02	SCLPCXX	VARIABLE	PART,CLEAN WITH SOLVENT AND BRUSH STARTS-WITH REACH TO GET PART(S) INCLUDES-ALL THE MOTIONS NECESSARY TO GET PART(S)AND PLACE ON WORKBENCH,PUT ON FACE SHIELD AND GLOVES,GET PART AND BRUSH,SIT,HOLD PART AND BRUSH IN SOLVENT TANK,BRUSH TO CLEAN RUST OR CORROSION FROM PART,STAND,ASIDE PART AND BRUSH,REMOVE AND ASIDE GLOVES AND FACE SHIELD ENDS-WITH REMOVE AND ASIDE FACE SHIELD CONDITIONS-DOES NOT INCLUDE WALKING TO GET PART OR TO AND FROM TANK
					1982	CASE 01 CLEAN FIRST PART-16 TO 25 SQUARE INCHES
					1271	02 CLEAN EACH ADDITIONAL PART-16 TO 25 SQUARE INCHES
					1742	03 CLEAN FIRST PART-NINE TO 16 SQUARE INCHES
					1031	04 CLEAN EACH ADDITIONAL PART-NINE TO 16 SQUARE INCHES
					1502	05 CLEAN FIRST PART-FOUR TO NINE SQUARE INCHES
					791	06 CLEAN EACH ADDITIONAL PART-FOUR TO NINE SQUARE INCHES

DEFENSE WORK MEASUREMENT STANDARD TIME DATA ELEMENTS

DATA SOURCE	OCCUPATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
FFE	599	MAA	OIGCGD6	SCLPWO1	555	PART,WASH IN TANK WITH BRUSH STARTS=WITH REACH TO TANK COVER HANDLE INCLUDES=ALL THE MOTIONS NECESSARY TO RAISE TANK COVER, OPEN VALVE,GET PART,DIP IN FLUID, GET BRUSH,DIP BRUSH IN FLUID,WIPE PART CLEAN WITH BRUSH,REMOVE PART AND BRUSH FROM FLUID AND ASIDE,REACH TO AGITATOR VALVE AND CLOSE, RELEASE VALVE,REACH AND GET TANK LID HANDLE, CLOSE LID,RELEASE LID HANDLE ENDS=WITH LID CLOSED,HANDLE RELEASED CONDITIONS=TANK LID WEIGHS TO 10 POUNDS
FFE	599	MAA	OIGSRL2	SDPPOXX	VARIABLE	PART,DIP IN SOLUTION(PAINT REMOVER) STARTS=WITH REACH TO GET PART INCLUDES=ALL THE MOTIONS NECESSARY TO PICK UP PART,PLACE PART IN SOLUTION,GET PART FROM SOLUTION,SHAKE TO REMOVE RESIDUE FROM PART, ASIDE PART ENDS=WITH ASIDE PART CONDITIONS=TANK PARTIALLY FULL OF PAINT REMOVER
					181	CASE 01 PART=2.5 TO 10 POUNDS
					194	02 PART=LESS THAN 2.5 POUNDS
FFD	599	MAA	GECWC9X	SJPDOXX	VARIABLE	DOORS(BASKET=HINGED,DOUBLE,SWINGING),OPEN AND CLOSE STARTS=WITH REACH TO LATCH INCLUDES=ALL THE MOTIONS NECESSARY TO UNLATCH DOOR(S)AND SWING FIRST DOOR OPEN,WALK TO SECOND DOOR AND SWING OPEN,GET FIRST DOOR AND SWING TO CLOSE,WALK TO SECOND,GET AND SWING TO CLOSE,ALIGN DOORS,PUSH SHUT AND SWING LATCH INTO EYE ENDS=WITH DOORS FULL OPEN OR CLOSED AND LATCHED CONDITIONS=5X5 FOOT BASKET
					399	CASE 01 OPEN
					464	02 CLOSE
FFD	599	MAA	GECCHR5	SJPGP01	311	GUN(SPRAY,RINSE),PREPARE TO USE STARTS=WITH REACH TO VALVE ON SPRAY GUN INCLUDES=ALL THE MOTIONS NECESSARY TO GRASP SPRAY GUN VALVE(WHEEL),TURN TWO REVOLUTIONS TO OPEN,GET SPRAY GUN AND POSITION FOR USE,PLACE GUN ASIDE,GRASP AND TURN VALVE WHEEL TWO REVOLUTIONS TO CLOSE,RELEASE VALVE ENDS=WITH RELEASE VALVE
FFD	599	MAA	GECCHS2	SJPGP02	440	GUN(STEAM),PREPARE TO USE STARTS=WITH SIDESTEP TO STEAM VALVE(ONE STEP) INCLUDES=ALL THE MOTIONS NECESSARY TO SIDESTEP AND GRASP VALVE WHEEL,TURN WHEEL TWO REVOLUTIONS TO OPEN,GET STEAM GUN,STEP BACK(TWO STEPS)CHANGE HANDS WITH GUN,STEP FORWARD(TWO STEPS),PLACE GUN IN SLOT IN GRATING,PLACE GUN ASIDE,GRASP VALVE WHEEL AND TURN TWO REVOLUTIONS TO CLOSE ENDS=WITH STEAM VALVE CLOSED,RELEASED
MAA	599	MAA	SCLVC01	SJPPP01	937	PART(S),PREPARE TO CLEAN WITH VARSOL STARTS=WITH REACH TO GOGGLES INCLUDES=ALL THE MOTIONS NECESSARY TO GET AND PUT ON GOGGLES,GET PART OR BASKET AND PLACE ASIDE IN SPRAY BOOTH,TURN FROM SPRAY BOOTH, PUT ON GLOVES,START EXHAUST FAN,GET AND ASIDE SPRAY GUN,GET AND ASIDE AIR GUN,GET PART OR BASKET,TURN AND ASIDE TO WORKBENCH,REMOVE GOGGLES,REMOVE GLOVES,TURN OFF EXHAUST FAN ENDS=WITH PART OR BASKET ASIDE,GLOVES REMOVED CONDITIONS=APPLIES TO SUCTION TYPE,VARSOL=AIR SPRAY WASH,AIR DRY,EQUIVALENT TO PAASCHE MODEL NUMBER SP L-4-DOES NOT INCLUDE TIME TO WASH OR DRY PART-DOES NOT INCLUDE WALKING

DATA SOURCE	CLASSIFICATION	QUALITY	SOURCE CODE	DMMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
FFE	599	FUA	DIGCG08	SCLPC07	1800	PART,CLEAN WITH PRESSURE SPRAY OF CLEANING AGENT STARTS-WITH REACH TO GET PART INCLUDES-ALL THE MOTIONS NECESSARY TO GET PART AND POSITION TO SPRAY NOZZLE,TURN SWITCH ON, PLACE FOOT ON FOOT PEDAL AND DEPRESS,SPRAY PART,REMOVE FOOT FROM PEDAL,TURN OFF SWITCH, PLACE PART ON WORK BENCH ENDS-WITH PART ASIDE CONDITIONS-1667 TMUS SPRAY TIME IS INCLUDED-WALKING AND TURNS AT WORK AREA NOT INCLUDED
FFD	599	TCA	GECCHR8	SCLPR01	7327	PARTS(IN BASKET),RINSE(SPRAY) STARTS-WITH REACH TO SPRAY VALVE TO OPEN INCLUDES-ALL THE MOTIONS NECESSARY TO TURN ON SPRAY VALVE(WHEEL)(TWO REVOLUTIONS),GET SPRAY GUN AND SPRAY PARTS IN BASKET TO RINSE,ASIDE SPRAY GUN,CLOSE VALVE ENDS-WITH GUN ASIDE,VALVE CLOSED CONDITIONS-TIME IS TO SPRAY RINSE A SMALL BASKET OF PARTS-PARTS CLOSE TOGETHER-COMPLEX SURFACES
FFD	599	TBA	GECCHR3	SCLPR02	1710	PARTS(IN BASKET),RINSE(SPRAY) STARTS-WITH REACH TO GET HOSE NOZZLE INCLUDES-ALL THE TIME AND MOTIONS NECESSARY TO GET NOZZLE,POINT NOZZLE AT BASKET,TURN ON SPRAY,RINSE BASKET OF PARTS,TURN SPRAY OFF, ASIDE NOZZLE ENDS-WITH ASIDE NOZZLE CONDITIONS-PARTS IN 5X5 FOOT BASKET OVER VAT-PARTS LOOSELY PLACED IN BASKET-SIMPLE SURFACES-TIME IS PER BASKET OF PARTS
FFE	599	MBA	DIGSRL1	SCLPSXX	VARIABLE	PAINT,STRIP FROM PART STARTS-WITH REACH TO GET PART INCLUDES-ALL THE MOTIONS NECESSARY TO GET PART AND DIP IN PAINT REMOVER,REMOVE PART AND SHAKE TO REMOVE RESIDUE,ASIDE PART,GET PART AND HOLD IN PRESSURE SPRAY,TURN PART SO THAT ALL AREAS ARE SPRAYED,SHAKE OFF RESIDUE,ASIDE PART,GET PART AND HOLD IN THINNER,GET LARGE BRUSH AND BRUSH PART TO REMOVE PAINT,ASIDE BRUSH,GET SMALL BRUSH AND BRUSH OFF REMAINING AREA OF PART,ASIDE BRUSH,GET RAG AND WIPE PART DRY, ASIDE RAG AND PART ENDS-WITH ASIDE PART CONDITIONS-PAINT REMOVER TANK IS PARTIALLY FULL-NO WALKING IN CONNECTION WITH THIS OPERATION IS INCLUDED CASE 01 PART-2.5 TO 10 POUNDS 1952 02 PART-LESS THAN 2.5 POUNDS 1439
FFE	599	MBA	DITITK1	SCLPS03	1452	PAINT,STRIP FROM INSTRUMENT CASE STARTS-WITH REACH TO INSTRUMENT CASE IN BASKET OF CASES INCLUDES-ALL THE MOTIONS NECESSARY TO GET ONE CASE FROM BASKET,GET BRUSH,CLEAN CASE WITH BRUSH,ASIDE BRUSH,GET WIPING RAG,GET AND OPEN SOLVENT CONTAINER,WET TOWEL,ASIDE CONTAINER, MOVE WET TOWEL TO SURFACE AND CLEAN SURFACE, ASIDE WET TOWEL,GET DRY TOWEL AND WIPE SURFACE,CLOSE AND ASIDE SOLVENT CONTAINER, VISUALLY INSPECT CASE,ASIDE CASE TO TRAY ENDS-WITH ASIDE CASE CONDITIONS-CASES HAVE BEEN REMOVED FROM DRYER IN A BASKET-CLEAN AREA TO ONE SQUARE FOOT-REMOVE LOOSE PAINT

DEFENSE WORK MEASUREMENT STANDARD TIME DATA ELEMENTS

DATA SOURCE	OCCUPATION	QUALITY	SOURCE CODE	DWMSTDP ELEMENT	TMU VALUE	OPERATION/ELEMENT DESCRIPTION
FEE	599	MAA	DIGCP01	SJPPP02	787	PART,PREPARE TO TANK CLEAN STARTS-WITH REACH TO GET PART(S)TO BE CLEANED INCLUDES-ALL THE MOTIONS NECESSARY TO PICK UP PART,PLACE PART ON WORKBENCH,SIT IN CHAIR,PUT ON FACE SHIELD,PUT ON GLOVES,GET PART AND DIP INTO SOLVENT IN TANK,REMOVE AND ASIDE PART, TAKE OFF AND ASIDE GLOVES AND FACE SHIELD, STAND UP ENDS-WITH STAND UP
NO	599	MAO	LTUM1G1	SJPRMXX	VARIABLE	ROCKS/COMPOUND,MOVE FROM DRUM TO CONTAINER STARTS-WITH REACH TO GET SCOOP INCLUDES-ALL THE MOTIONS NECESSARY TO GRASP, DIP INTO DRUM AND GET SCOOP LOAD,REMOVE LOAD FROM DRUM AND TO CONTAINER,DUMP SCOOP LOAD IN CONTAINER,RETURN SCOOP TO DRUM AND RELEASE ENDS-WITH RELEASE SCOOP IN DRUM
					234	CASE 01 FIRST OR ONLY SCOOP LOAD
					197	02 EACH ADDITIONAL SCOOP LOAD
MAA	599	MAA	SCLCC49	SJPSS01	1518	STEAM UNIT,SET UP AND SECURE STARTS-WITH REACH TO PLUG INCLUDES-ALL THE MOTIONS NECESSARY TO PLUG IN AND UNPLUG POWER CORD,OPEN AND CLOSE TWO GLOBE TYPE STEAM VALVES(NOT MORE THAN SEVEN TURNS EACH),OPEN AND CLOSE WATER VALVE(LEVER TYPE OR PETCOCK,TURN NOT MORE THAN 180 DEGREES), OPEN AND CLOSE SOAP VALVE(PUSH TYPE SWITCH), OPEN AND CLOSE WATER TANK VALVE(LEVER TYPE OR PETCOCK,TURN NOT MORE THAN 180 DEGREES) ENDS-WITH PULL POWER PLUG CONDITIONS-DOES NOT INCLUDE WALKING TO OR FROM MACHINE OR TO OR FROM POWER CORD PLUG
NO	599	MAA	LTUM-1N	MNFDL01	105	DOOR(TUMBLER),LOCK OR UNLOCK STARTS-WITH REACH TO DOOR LATCH INCLUDES-ALL THE MOTIONS NECESSARY TO REACH TO AND HIT DOOR LATCH WITH FIRST ONE HAND AND THEN THE OTHER TO LOOSEN OR TIGHTEN LATCH, GRASP LATCH IN BOTH HANDS AND MOVE TO LOOSEN OR TIGHTEN,RELEASE LATCH ENDS-WITH RELEASE LATCH CONDITIONS-HIT LATCH THREE TIMES WITH EACH HAND-DOOR IS 12 X 14 INCHES WITH 2 DOG LOCKS
NO	599	MAO	LTUM-1R	MDHDP01	49	DOOR(TUMBLER),POSITION ON TUMBLER STARTS-WITH DOOR IN HANDS INCLUDES-ALL THE MOTIONS NECESSARY TO MOVE DOOR TO MACHINE,POSITION DOOR ON MACHINE,MOVE OTHER END OF DOOR INTO PLACE,POSITION,RELEASE DOOR ENDS-WITH RELEASE DOOR CONDITIONS-DOOR IS 12 X 14 INCHES
NO	599	MAO	LTUM-1Q	MDHDR01	39	DOOR(TUMBLER),REMOVE STARTS-WITH REACH TO DOOR HANDLE INCLUDES-ALL THE MOTIONS NECESSARY TO GRASP DOOR HANDLE,DISENGAGE DOOR AND MOVE DOOR ASIDE ENDS-WITH DOOR MOVED ASIDE,STILL IN HAND CONDITIONS-DOOR IS 12 X 14 INCHES

* U. S. GOVERNMENT PRINTING OFFICE : 1975